

Work Order ID 121569

Thursday, June 26, 2014 3:03:30 PM

121569

Page 1

Item ID: D4807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 6/26/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-06-30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4807	B								

105

0.00

105

Outsource5

Outsource process - Machining

Memo

Issue P/O: 24875

Machine as per Dwg D4807

Possible Supplier: Archer Precision

Conformity sheet required

and Material Certs for material supplied

0.00

CL 14/07/04 6

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

P 4/8/0 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

Item ID: D4807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 6/26/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00						DAS 9 9-89	38 9-89 14-8-25
Quality Control									
124		0.00							
124									
Purchasing	Memo	0.00							
Purchasing	Issue P/O FOR LIQUID PENETRATION P/O #: <u>25608</u>								
	Certificate of conformity is required								
125	Receive & Inspect for Damage & Mat'l Certs	0.00							
125									
Packaging	Memo	0.00							
Packaging	ENSURE NDT RESULT IS ATTACHED								

⑥

25608

CDL14109104 ⑥

PA141717 ⑥

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
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Work Order ID 121569

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Page 4

Item ID: D4807-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support Assembly

Stop ***NS2***

Start Date: 6/26/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-09-09
MLJ 14-09-09

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Doc/Data									
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Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

Thursday, June 26, 2014 3:03:29 PM

Page 1

Work Order ID: 121569

121569

Parent Item: D4807-041

D4807-041

Parent Item Name: Support Assembly

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD IPP
REV:B 14.06.19 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D4807-1P		Purchased	No				Each	0.0000		6				
D4807-1P										**	121569 C 14/8/15 (6)			
Support														
D5113-1		Manufactured	No				Each	0.0000		6				
D5113-1										**	6 FF 14-09-08			
Bushing														
NAS77C6-017		Purchased	No				Each	4.0000		6				
NAS77C6-017										**	FF 14-09-08			
Bushing														
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
						ST277	4							
						M128110	4							
											6			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

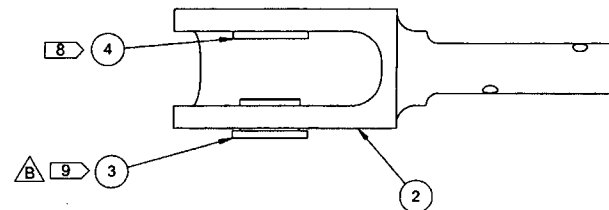
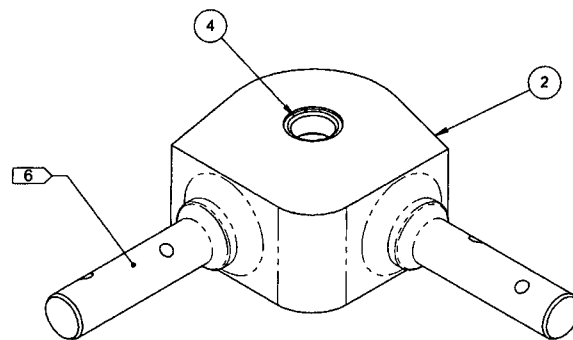
FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4807-041	SUPPORT ASSEMBLY
2	1	D4807-1	SUPPORT
3	1	D5113-1	BUSHING
4	1	NAS77C6-017	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121569 MLJ

14-0630



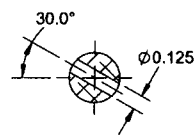
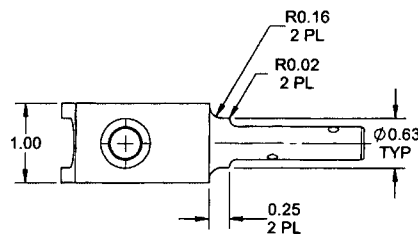
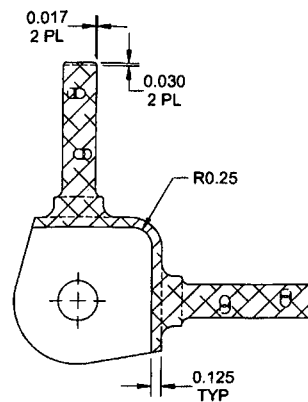
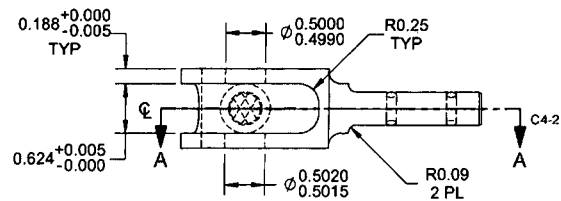
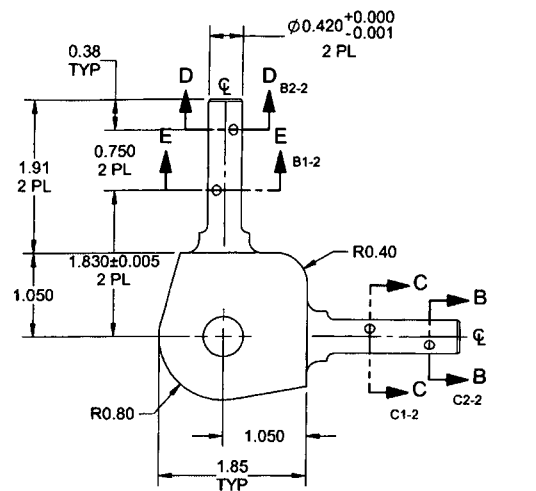
D4807-041 SUPPORT ASSEMBLY

NOTES:

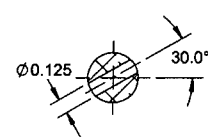
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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) NAS77C6-017 BUSHING IS PRESS FIT ON $\varnothing 0.500$ HOLE
- 9) D5113-1 BUSHING IS SLIDE FIT ON $\varnothing 0.502$ HOLE

RELEASED
2014-06-16

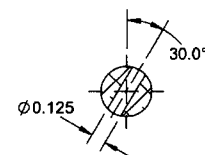
B	D5113-1 WAS NAS75C6-009 (ZN D3-1, B4-1, A8-1); REVISE NOTE 8 & 9 (ZN A8-1)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4807	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SUPPORT ASSEMBLY	NTS
DATE	14.04.08	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



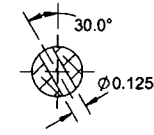
SECTION B-B C6-2



SECTION C-C C6-2



SECTION D-D D7-2



SECTION E-E D7-2

D4807-1 SUPPORT

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL BAR, H900 CONDITION
PER AMS 5604/5643
DART SPEC M17-4-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASE
2014-06-16

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4807	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SUPPORT ASSEMBLY	NTS
DATE	14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24875**

Purchase Order Date 7/4/2014

PO Print Date 7/4/2014

Page Number 1 of 2

Order From :

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

VC-GLO001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

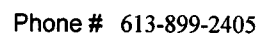
FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4807-1P	Support	8/15/2014 Yes 8/15/2014	FN	4.00 Each	\$641.96	\$2,567.84
MACHINE AS PER DWG D4807 REV. B B121570							
Line Total:							\$2,567.84
2	D4807-1P	Support	8/15/2014 Yes 8/15/2014	FN	6.00 Each	\$641.96	\$3,851.76
AS PER DWG D4807 REV. B B121569							
Line Total:							\$3,851.76

Note:

7/4/2014



Date	Invoice #
7/31/2014	1101

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
24875	7/31/2014	delivered	Archer	

Qty	Item Code	Description
<div>4</div> <div>6</div>	<div>Sales</div> <div>Sales</div>	<div>D4807-1P</div> <div>D4807-1P</div> <div>HST (ON) on sales</div>



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

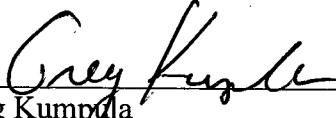
Certificate of Compliance

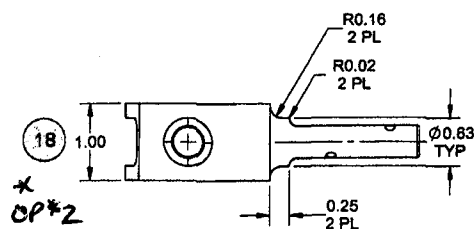
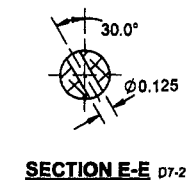
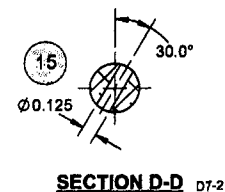
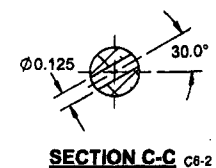
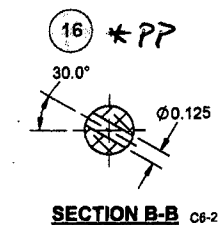
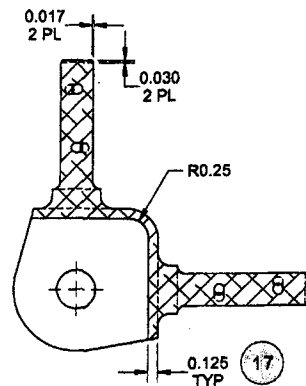
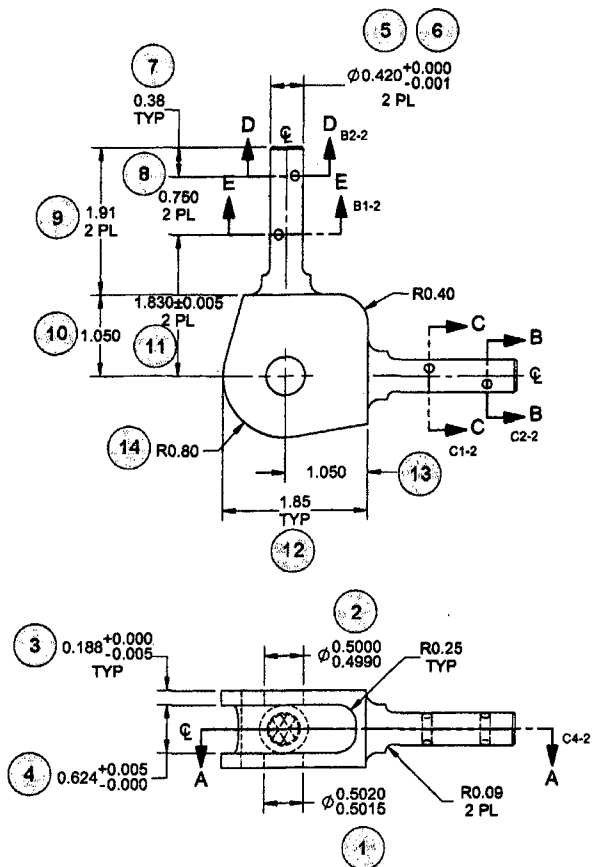
To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

31 July 2014

Po Number	Part Number	Quantities
24875	D4807-1P	4
	D4807-1P	6

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 24875 issued by Dart Aerospace Inc.


Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



D4807-1 SUPPORT

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL BAR, H900 CONDITION
PER AMS 5804/5643
DART SPEC M17-4-B
- 2) FINISH: N/A
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- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4807	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	SUPPORT ASSEMBLY	NTS
DATE	13.12.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Archer Precision

Short date 7/29/14

FAIRWAY

Plan Name D4807-1
 Customer: * u_cus *
 u_jobnum * u_jobnum *
 Customer PO.: * u_Cuspo *
 u_mtl * u_mtl *

Part No.: * u_prtnu *
 Rev.:
 u_qtynu * u_qtynu *
 BSN: D4807-1P
 Incr. Smpl No.: 7

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
1 - Dia_Cylinder1	D	0.50189	0.50175	0.50200	0.50150	0.00014	—
2 - Dia_Cylinder2	D	0.49930	0.49950	0.50000	0.49900	-0.00020	—
3 - Slot Top	Z	-0.18530	-0.18800	0.00500	0.00000	0.00270	—
4 - Slot Width	CartDist	0.62470	0.62400	0.00500	0.00000	0.00070	—
5 - Dia_Post 1	D	0.41979	0.42000	0.00000	-0.00100	-0.00021	—
6 - Dia_Post2	D	0.41979	0.42000	0.00000	-0.00100	-0.00021	—
7 - Post 1 End to Hole	CartDist	0.38008	0.38000	0.01000	-0.01000	0.00008	—
7 - Post 2 End to Hole	CartDist	0.38045	0.38000	0.01000	-0.01000	0.00045	—
8 - Cross Hole Distance	CartDist	0.74987	0.75000	0.00500	-0.00500	-0.00013	—
8 - Cross Hole Distance 2	CartDist	0.74957	0.75000	0.00500	-0.00500	-0.00043	—
9 - Post 1 Length	CartDist	1.90813	1.91000	0.01000	-0.01000	-0.00187	—
9 - Post 2 Length	CartDist	1.90819	1.91000	0.01000	-0.01000	-0.00181	—
10 - Side 1	Y	1.05356	1.05000	0.00500	-0.00500	0.00356	—
11 - Hole Distance 1	Y	1.83128	1.83000	0.00500	-0.00500	0.00128	—
11 - Hole Distance 2	X	1.82966	1.83000	0.00500	-0.00500	-0.00034	—
12 - Base Width 1	ResEle	1.85418	1.85000	0.01000	-0.01000	0.00418	—
12 - Base Width 2	ResEle	1.85278	1.85000	0.01000	-0.01000	0.00278	—
13 - Side 2	X	1.05217	1.05000	0.00500	-0.00500	0.00217	—
14 - Dia	D	1.60123	1.60000	0.01000	-0.01000	0.00123	—
15 - Dia_Circle1	D	0.12510	0.12500	0.00400	-0.00100	0.00010	—
15 - Dia_Circle2	D	0.12488	0.12500	0.00400	-0.00100	-0.00012	—
15 - Dia_Circle3	D	0.12520	0.12500	0.00400	-0.00100	0.00020	—
15 - Dia_Circle4	D	0.12511	0.12500	0.00400	-0.00100	0.00011	—
17 - Wall Thickness	CartDist	0.12638	0.12500	0.00500	-0.00500	0.00138	—

OP#2

18 - O/A THICKNESS MEASURED 1.004" TOLERANCE ± .01



skyservice
Air travel. Evolved.

NDT Work Order

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: YYZ

70279

Customer: DART AEROSPACE

Dept: NDT YYZ

Reference: 25608

Make:

Model:

Reg:

A/C S/N:

TSN:

CSN:

TSO:

Tail#:

Task: ☒ Scheduled ☐ Unscheduled ☐ A.O.G. ☒ P.T. ☐ M.T. ☐ E.T. ☐ U.T. ☐ R.T.

Work Required:

CARRY OUT NDT IAW ITEM ID'S AND ITEM NAMES LISTED BELOW;

① ITEM ID = D4807-041 WORK ORDER ID'S 121570, 123237, 122320, 121569 TOTAL QTY = 17

② ITEM ID = D4881-1 WORK ORDER ID'S 121698, QTY 12

③ ITEM ID = D4882-1 WORK ORDER ID 121622 QTY=10

④ ITEM ID = D4880-1 WORK ORDER ID 121611 QTY=6

Action Taken:

Date:

Initial/Stamp:

LIQUID PENETRANT INSPECTION CARRIED

OUT ON ITEMS LISTED ABOVE

IAW ASTM E1417 - M13

03 SEPT
2014



NO CRACKS FOUND

BLACK LIGHT - T-20990N

PENETRANT = ARDROX 970P25 E

BATCH #

02312131

I certified that the maintenance described above has been performed with the applicable standard of airworthiness.

Signature:

Gary Smith

ACA/SCA Stamp



Date:

03 SEPT
2014

Name: GARY SMITH